Work Orde September-13-12	er ID 89930 2 8:27:26 AM			*899	30*							Page 1	
Revision ID: tem Name:	D412-698-032 Cabin Door Roller, RH 9/12/12 Start Qt	v: 1.00	*1*	Accept	*N900		100)*	Setup	Start Stop		S1* S2*	_
Required Date:	_	-	*1*		Customer:		_		n	C4 mm4			
Approvals:	Process Plan: ML	.ブ	Date: \2 09 12	Tooling: SPC (Y/N):	,,,	oate:			Run	Start Stop		R1* R2*	
Sequence ID/ Work Center ID	Operation Descript			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr	:											
IIN D412-698	Rev E		AB	(ZAC)									
*100 *100* DC Document Control	DOCUME	NT CONTROL Memo Photocopy blu	Unuefile & type labels per f	0.00 (15) 0.00 (2) (2) (2) (2) (2) (2) (2) (2) (2) (2)) Э 9 н _{G001}			<u> </u>		-401	MLS	12-11	-2
10	Pick Kit			0.00									,
110 Packaging Packaging		Memo		0.00					<u>. </u>			12/11/2	1
20	QC4- 1009	6 Inspect kits fo	or completeness	0.00 (5)									
120 ^{QC}		Memo		% (1 Cl 00.0	5								

Quality Control

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	
Work Ord	or.				•	DISPOSITION				AGAINST DE	PARTMENT,	PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator												:	
Material													
Setup													
Other													1
Process								•					
Supplier													
Training													
Unapproved			<u> </u>	<u> </u>			<u> </u>						
							AUL	T CATE	GORY				
Landi	ng (1			_	General		ı			1	_	- 1
	<u> </u>	Bending			<u> </u>	Bend		Grain		-	Ovalized	_	Pressure/Forced
	L	Centre No	ot Concei	ntric to (D/S	BOM/Route		Hardwa			Over/Under	—	Temperature/Cure
	_	Cracks			<u> </u>	Broken/Damaged		,	ion Incomplete	_	Part Incorred	<u> </u>	Weld
		Crushed/	Crimped,		_	Burrs			ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			_	Contamination		Mainte			Part Moved		
1		Heat Trea			<u> </u>	Countersink	\vdash	Mislabe		ļ	Positioned V		- 1
	<u> </u>	Inspectio		Tube	<u> </u>	Cut Too Short	Ш	Misreac	d		Power Loss/	Surge	Other
	L	Ripples in			<u> </u>	Drill Holes		Offset					
		Torque W			` <u> </u>	Drawing	\vdash		Calibration				
		Turning S				Finish	Ш		Sequence				
	1	Wave/Tw	ist in Tub	oe 💮	1	Folio	1	Outside	Dimensions				

	•											
Work Ordenseptember-13-1				*890	330*							Page 2
Item ID: Revision ID:	D412-698-0	032		Accept	*N900	04 0	100)*	Setup	Start	*N.	S1*
Item Name:	Cabin Door I	Roller, RH								Stop	*N:	S2*
Start Date: Required Date: Reference:	9/12/12 : 10/05/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling:	Da	 ite:	_		Run	Start	*N	R1*
ripprovides			•	_		nte:				Stop	*N	R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
130				0.00			\sim A C			1	j	1
130 Packaging		Packaging Memo		0.00			0A. 20 3-89	· 	_3/		12/11	129
Packaging		031Location	pack for shipping as p	er PPP D412-698- Rev:			•				. ,	
140		QC21- Final Inspection	- Work Order Release	0.00					,	ر ۾ '	112	1200
*14 0 *		Memo		0.00						2		
Quality Control											0.01	1/

MF 12-11-20

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			
		QA Closed:	Date:	

										QA Closeu.	Date.			
Work Orde	er:	•			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	No				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other		
Root				Descri	ption of work order update	In	itial	Act	ion	Sign &		,		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector		
Doc/Data Equip/Tooling														
Operator Material										·				
Setup														
Other Process			4	·	`									
Supplier	-				:									
Training														
Unapproved														
,					FA	AULT	CATE	GORY						
Landir	ng Gear				General							_		
	Bending				Bend	∐ G	Grain			Ovalized		Pressure/Forced		
	Centre No	ot Concer	ntric to (o/s	BOM/Route	Щн	lardwa	re		Over/Under	tolerance	Temperature/Cure		
	Cracks				Broken/Damaged	-	•	on Incomplete		Part Incorred	ct	Weld		
	Crushed/	Crimped.		_	Burrs	∐lr	nstruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled		
	Cuffs				Contamination	∐^	∕lainte	nance		Part Moved				
	Heat Trea			•	Countersink	-	∕islabe		 	Positioned V		-		
	Inspection	-	Tube		Cut Too Short	-	∕lisread	l		Power Loss/	Surge	Other		
1	Ripples in			<u></u>	Drill Holes	$\boldsymbol{\vdash}$	Offset							
	Torque W		xtrusion	՝ _	Drawing	-		Calibration						
	Turning S	•		L	Finish	\vdash		Sequence						
	Wave/Tw	ist in Tub	e		Folio)utside	Dimensions						

Picklist Print

September-13-12 8:27:25 AM

Work Order ID:

89930

D412-698-032

Parent Item Name:

Cabin Door Roller, RH

Start Date: 9/12/12

Required Date: 10/05/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

								04	O4 7711			-	C4 - 4
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measu	Qty on re Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-144 Bracket Assembly		Manufactured	No			120	Each	9.0000	Į.	1 .	- ZB	0	
_				Location		Loc Qty	•	Loc Code					•
Sm				ST235A		9							
O ()				8549	92	3							
				8827	75	2							
4 .				8916	57	4			3.	1167			
D3137-048 Bracket Assembly		Manufactured	No			120	Each	15.0000		1	18		8
				Location		Loc Qty		Loc Code					
SMS				ST235A		13							
312				8586		9							
				8823	38	4			+0	3338			
				ST235B		2			- 8 7	<i>y</i>			
				7973	34	2							
D3183-044 Bracket Assembly		Manufactured	No			120	Each	10.0000		1	1 B	· · · · · · · · · · · · · · · · · · ·	
-				Location		Loc Qty		Loc Code					
				ST		-4							
J117				ST235B		14							
				8599		6				006			
				8911	8	4			8	9118			
03202-3 Cover		Manufactured	No			120	Each	10.0000	90	255	JB		2///
<i>~</i> . ^				Location		Loc Qty	ļ	Loc Code			Ť		T
SM)				ST241A		10							•
				6167	79	10							

Parent Item:

NCR: Y	es / No				WORK ORDER NON-	COI	NFOR	MANCE / UP	DATE			
	•									QA Closed:	Date	2:
Work Orde	r:				DISPOSITION	_			AGAINST DI	-	_	7
Part N	o				Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	Pro	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	0				Work Order Update			Large Fab	Composite	j ,	Supplier	
Root				Descri	ption of work order update		Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data								:				
Equip/Tooling												
Operator												
Material												
Setup]										
Other	_											
Process	_											
Supplier						i						
Training		İ										
Unapproved		<u> </u>										
						AUL	T CATE	GORY				
Landin	g Gear				General	_	1			٦	Г	-
}	Bending			, -	Bend	-	Grain		<u> </u>	Ovalized		Pressure/Forced
.	Centre No	ot Concer	ntric to O	^{1/S}	BOM/Route	-	Hardwa		-	Over/Under		Temperature/Cure
ŀ	Cracks	a		_	Broken/Damaged	\vdash	1 '	on Incomplete		Part Incorred		Weld
-	Crushed/	Crimped.			Burrs	-	4	ions Incomplete/I	Unclear	Part Lost/Mi	ssing [Wrong Stock Pulled
}	Cuffs			<u> </u>	Contamination	\vdash	Mainte		-	Part Moved		
	Heat Trea		T I	<u> </u>	Countersink	\vdash	Mislabe			Positioned V		John
-	Inspection	•	iube	<u> </u>	Cut Too Short	-	Misread	1		Power Loss/	Surge [Other
	Ripples in		<i>.</i>	-	Drill Holes	-	Offset	- 111				····
	Torque W	aves in E	xtrusion	L	Drawing		JUut of (Calibration				•

Out of Sequence

Outside Dimensions

Date:

DQA:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish Folio September-13-12 8:27:25 AM

Work Order ID:

89930

Parent Item:

D412-698-032

Parent Item Name:

Cabin Door Roller, RH

D3674-041

Manufactured

Manufactured

No

No

120

120

Each

8.0000

Start Date: 9/12/12

Start Qty: 1.00

Required Date: 10/05/12

Required Qty: 1.00

· BRACKET ASSEMBLY

Location ST236A

83188

Loc Qty

8 Each

24.0000

SLIDING DOOR BRACKET

Location ST236A

Loc Qty 86062

24 24 Loc Code

Loc Code

September-13-12 8:27:25 AM

Shop Packet Print

Page 2

										DQA	:Date	:: <u> </u>
NCR:	res / No				WORK ORDER NON-G	:OI	NFORI	MANCE / UPI	DATE	QA Closed	: Date	2:
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	No				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			-	Water Jet od. Eng. Coor. ore/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
					F.	AUL	T CATE	GORY		<u> </u>		
Landi	ng Gear				General					_		
	Bending Centre N Cracks Crushed Cuffs Heat Tre	lot Conce		o/s	Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		4 '	on Incomplete ions Incomplete/L nance Ied	Jnclear	Ovalized Over/Unde Part Incorre Part Lost/M Part Moved Positioned Power Loss	ect lissing l Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Ripples	n Bend			Drill Holes		Offset					_

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio



IIN-D412-698

Page 25 of 25

8.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 412-030-300-XXX COMPOSITE DOORS)

Qty	Qty	Qty ,	_Qty、	Qty	Qty		
-019	-021	-031	032 ⁾	-033	-035	Part Number	Description
Х		·				D412-698-019	BEARING OVERHAUL KIT
	Х					D412-698-021	REPLACEMENT SHIM KIT
		Х				D412-698-031	CABIN DOOR ROLLER KIT, LH
			Х			D412-698-032	CABIN DOOR ROLLER KIT, RH
				Х		D412-698-033	REPLACEMENT DOOR TRACK KIT
					Х	D412-698-035	DOOR HANDLE KIT
7						D3121-21	BOLT
5						D3121-21	BEARING ASSEMBLY
1						D3121-241	GUIDE
1			 			D3137-5	WASHER
2			-			D3183-045	BEARING ASSEMBLY
			<u> </u>			D3 103-043	DEAINING MODEWIDE I
	3					D3238-1	SHIM
	1					D3238-3	SHIM
	2					D3238-5	SHIM
	6					D3238-11	SHIM
	2					D3238-13	SHIM
	4					D3238-15	SHIM
		1				D3121-143	BRACKET ASSEMBLY
			4			D3121-144	BRACKET ASSEMBLY
		1	اك			-D3137-043	-BRACKET-ASSEMBLY
		1				D3183-043	BRACKET ASSEMBLY
	<u> </u>		9			D3183-044	BRACKET-ASSEMBLY
		1		=1-		D3202-3	COVER
		3	-3-		-	=D3674=041	BRACKET-ASSEMBLY
		9	= 9=	<u>=9=</u>		-D3675-1	-BRACKET-
					2	D3779-041	HANDLE ASSEMBLY
					2	D3779-3	PLATE
		†··-	<u> </u>		2	D3779-043	HANDLE ASSEMBLY
					12	AN525-832R8	SCREW
\vdash	-	 			12	AN960JD10L	WASHER
		-	<u> </u>		12	MS21042L3	NUT
<u> </u>	-		1				
	-	-			12	MS24694-S58	SCREW
1	j					MS24694-S101	SCREW